Date: Monday, 4/23/2007 1:51:42 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI UTILITY BASKET LH/RH 350/355
Job Number	: 31989		
Estimate Number	: 10208		
P.O. Number	: N/A	Part Number	: D350607043
This Issue	: 4/23/2007 S.O. No. : N/A	Drawing Number	: D350-607 REV F P7-9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 31988	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: 07.04.23		
Comment	: Est Rev:E as Per DSI9318 06-01-24 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile & type labels per PPPD350-607-043 CHG003 KJ 07.06.06 (1)

2.0	31989A	BASKET LID ASSEMBLY

Comment: Sub-Component BASKET LID ASSEMBLY
D2989-041 B 31989 A ml 07/06/28

3.0	31989B	BASKET LID ASSEMBLY

Comment: Sub-Component BASKET LID ASSEMBLY
D2989-043 B 31989 B ml 07/06/28

4.0	31989C	BASKET BASE ASSEMBLY (350)

Comment: Sub-Component BASKET BASE ASSEMBLY (350)
D2221 B 31989C ml 07/06/28

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Assemby Kit

6.0	NAS1515H4	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	NAS1515H4	WASHER	7101428

07/06/28

Form: rnprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:51:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31989 | **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
7.0	D2022101	Spacer

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
5 D2022-101 Spacer B30543 —

Seq. #:	Machine Or Operation:	Description :
8.0	D2258200	Weight Placard 200lb

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2258-200 Label B31104 —

Seq. #:	Machine Or Operation:	Description :
9.0	D2332041	Lid Prop Assembly 6.69"

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2332-041 Prop Ass'y B31694

Seq. #:	Machine Or Operation:	Description :
10.0	D2530	Handle Weldment

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
1 D2530 Handle Weldment B31106

Seq. #:	Machine Or Operation:	Description :
11.0	D2535	Spring

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2535 Spring B31486 —

Seq. #:	Machine Or Operation:	Description :
12.0	D2537	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 D2537 Bushing B31107 —

07/06/28

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:51:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31989 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	D27283	Dart Logo label large

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2728-3	Label	B22553

Seq. #:	Machine Or Operation:	Description :
14.0	D2931	Bumper

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	D2931	Bumper	B21139

Seq. #:	Machine Or Operation:	Description :
15.0	AN316A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN3-16A	Bolt	M103691

Seq. #:	Machine Or Operation:	Description :
16.0	AN413A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
2	AN4-13A	Bolt	M104118

Seq. #:	Machine Or Operation:	Description :
17.0	AN422A	Bolt

Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
7	AN4-22A	Bolt	M104214

Seq. #:	Machine Or Operation:	Description :
18.0	AN517A	Bolt

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit

Qty	Part Number	Description	Batch
4	AN5-17A	Bolt	M104016

07/06/28

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:51:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31989 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
19.0	AN960JD8	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD8 Washer M104156

20.0	AN960JD416	Washer

Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
14 AN960JD416 Washer M103691

21.0	AN960JD416L	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 AN960JD416L Washer M104214

22.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M103694

23.0	AN9704	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 AN970-4 Washer M103344

24.0	MS20600AD4W3	Cherry Rivets

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS20600AD4W3 Rivet M102929

07/06/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 4/23/2007 1:51:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31989 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M103691

Seq. #:	Machine Or Operation:	Description :
26.0	MS21042L4	Nut

Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
9 MS21042L4 Nut (or -4) M102552

Seq. #:	Machine Or Operation:	Description :
27.0	MS21042L5	Nut

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Assemby Kit
Qty Part Number Description Batch
4 MS21042L5 Nut (or -5) M103446

07/06/28

Seq. #:	Machine Or Operation:	Description :
28.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D350-607
Seal Support Gusset with Sikaflex -291
Batch: M103497
Exp Date: 10/2007

XL
ML 07/06/28

Seq. #:	Machine Or Operation:	Description :
29.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

07/06/28 (XL)

Seq. #:	Machine Or Operation:	Description :
30.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick: Packing Kit

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:51:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services — **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31989 — **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	D22301	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-1	Lug	B30992

Seq. #:	Machine Or Operation:	Description :
32.0	D22303	Mounting Lug

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2230-3	Clamp	B30993

Seq. #:	Machine Or Operation:	Description :
33.0	D23241	Strut Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
1	*D2324-1	Strut Ass'y	B31270

Seq. #:	Machine Or Operation:	Description :
34.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 0.6000 f(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
4	D2856-400-720	Abrasion Strip	B32020

Seq. #:	Machine Or Operation:	Description :
35.0	AN412A	Bolt

Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
5	AN4-12A	Bolt	M103962 (2x) M104291 (3x)

Seq. #:	Machine Or Operation:	Description :
36.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Pick: Packing Kit

Qty	Part Number	Description	Batch
8	AN4-13A	Bolt	M104118

07/06/28

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ PAR #: _______ Fault Category: ________________ NCR: Yes $\boxed{\text{No}}$ DQA: D Date: 07/02/09

QA: N/C Closed: _____ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:51:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** HELI UTILITY BASKET LH/RH 350/355

Job Number: 31989 **Part Number:** D350607043

Job Number:

Seq. #:	Machine Or Operation:	Description :
37.0	AN960JD416	Washer

Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
26 AN960JD416 Washer M103691

Seq. #:	Machine Or Operation:	Description :
38.0	MS21042L4	Nut

Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
13 MS21042L4 Nut (or -4) M102552 07/06/28 (1)

Seq. #:	Machine Or Operation:	Description :
39.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 07/06/29 (1) 07/6/29 (1)

Seq. #:	Machine Or Operation:	Description :
40.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-607-043
Location: K 07/6/29 (1)

Seq. #:	Machine Or Operation:	Description :
41.0	QC21	FINAL INSPECTION/W/O RELEASE

(1)

Comment: FINAL INSPECTION/W/O RELEASE 07/06/29

Job Completion

07.06.29

Dart Aerospace Ltd

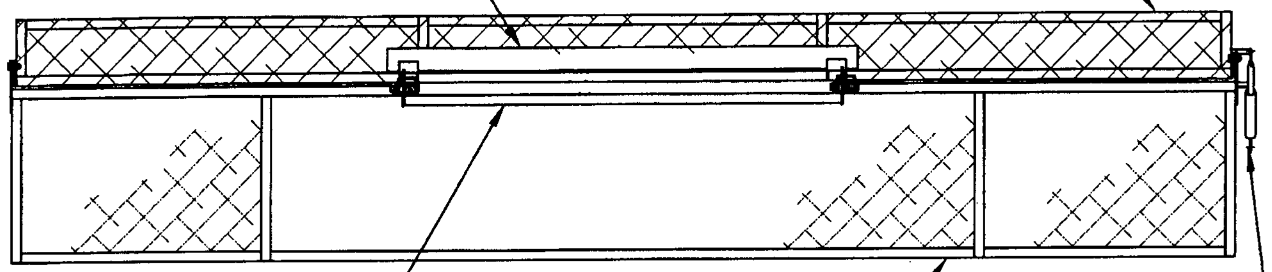
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

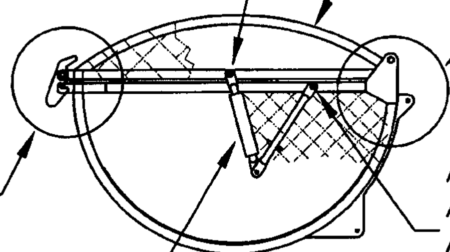
Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

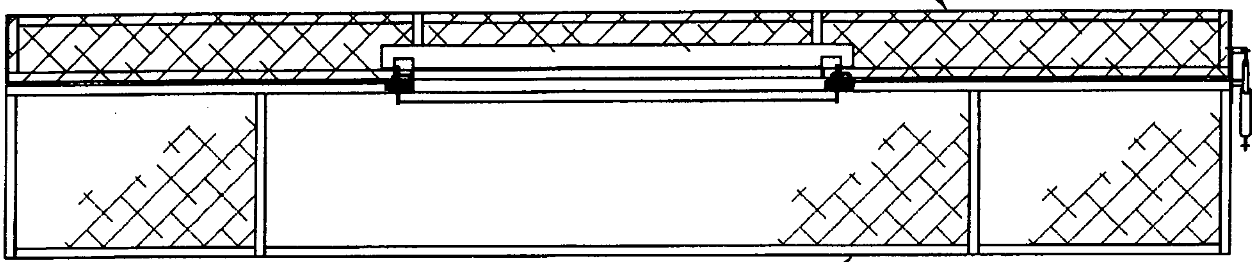
NOTE: Date & initial all entries

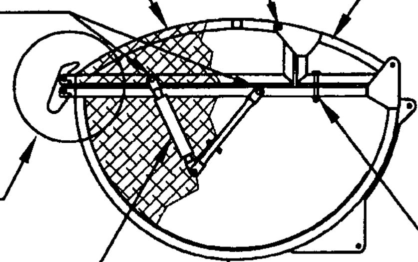




PROP ARM DETAIL
(VIEW C-C)

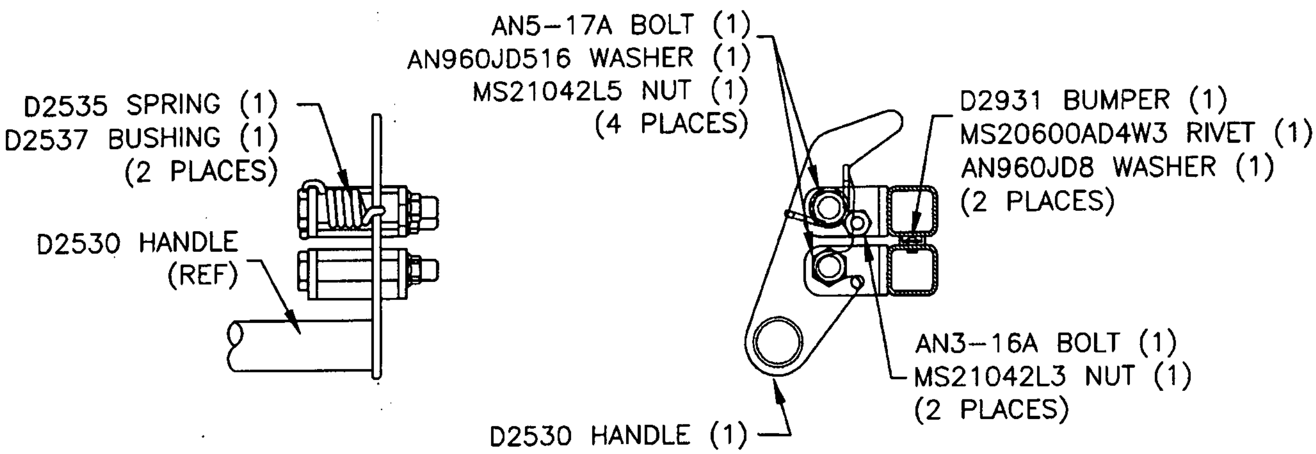
Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)





PROP ARM DETAIL
VIEW C-C

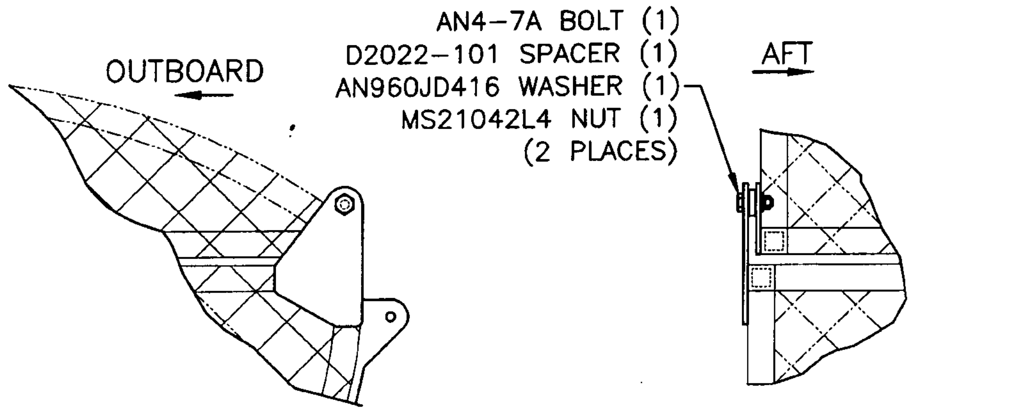
Figure 5– Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)



SPRING DETAIL

LATCH DETAIL

DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

Figure 6 – Basket Replacement Parts

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

DART

DART SERVICE INSTRUCTION

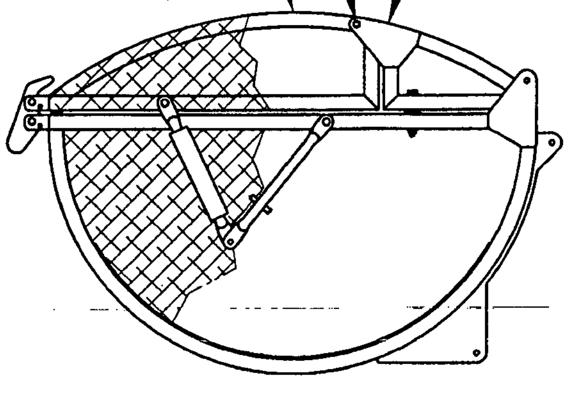
TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047** *Heli-Utility-Basket*.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:



CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 06.01.06
CERT. NO.: SH94-14
ISSUE NO.: 4

Date: Monday, 4/23/2007 1:52:26 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)
Job Number	: 31989C		
Estimate Number	: 10189		
P.O. Number	: N/A	Part Number	: D2221
This Issue	: 4/23/2007 S.O. No. : N/A	Drawing Number	: D2221/D2235
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: F/B1
Previous Run	: 31988C	Material	: N/A
Written By	:	Due Date	: 4/30/2007 Qty: 1 Um: Each
Checked & Approved By	: [signature] 07.04.23		
Comment	: Est RevJ 05.09.02 Added D3442-1 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31661	Basket Hoop

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D3166-1	RIB	B30825 → 1 fois B31701 → 3 [initials] 07/06/18

✓

Seq. #:	Machine Or Operation:	Description :
2.0	D22323	Basket Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2232-3	Hinge bracket	B30873

✓ [initials] 07-06-25

Seq. #:	Machine Or Operation:	Description :
3.0	D2325	Support Gusset (350 Bask

Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
4	D2325	Support Gusset	B31423

✓ [initials] 07-06-25

Seq. #:	Machine Or Operation:	Description :
4.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B31785

✓ [initials] 07-06-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET BASE ASSEMBLY (350)

Job Number: 31989C **Part Number:** D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D2581	Mounting Bracket

✓ **Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D2581 Mounting Bracket B31189 Cpl 07·06·25

Seq. #:	Machine Or Operation:	Description :
6.0	D34421	Shim

✓ **Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 D3442-1 Shim B30564 Cpl 07·06·25

Seq. #:	Machine Or Operation:	Description :
7.0	M304EX07516F	Expanded Metal Flat Stai

✓ **Comment:** Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)
Pick:
Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal M104001 Cpl 07·06·25

Seq. #:	Machine Or Operation:	Description :
8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

✓ **Comment:** Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)
Pick:
28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing
Batch: M103946 SJ. 07/06/15 Cpl 07·06·25

Seq. #:	Machine Or Operation:	Description :
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235 SJ. 07/06/19

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr SJ. 07/06/19

4-Remove all markings on material before welding SJ 07/06/15

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required Cpl 07·06·25

Form: mprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** D **Date:** 07/06/29

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:52:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 31989C

Part Number: D2221

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	07/06/26
11.0	QC6	DIMENSIONAL CHECK
	Comment: DIMENSIONAL CHECK	07/06/26
12.0	POWDER COATING	POWDER COATING
	M 104 144	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	BK/M. 07-06-27.
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	ML 07/06/28
14.0	QC21	FINAL INSPECTION/W/O RELEASE
		(1)
	Comment: FINAL INSPECTION/W/O RELEASE	07/06/25

Job Completion

U 07.06.29

Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

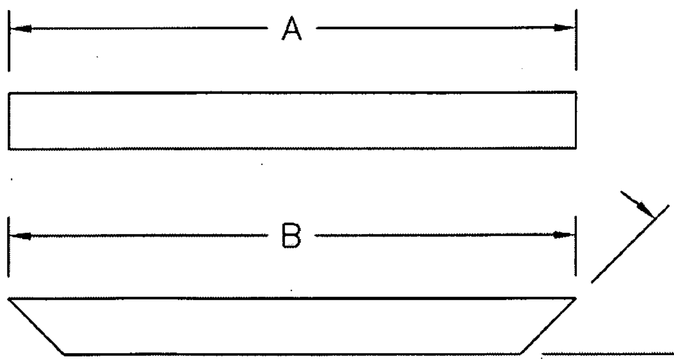
DESIGN	DRAWN-BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	PH	
CHECKED	APPROVED	DRAWING NO. D2221 — REV. F — SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) — SCALE NTS

RELEASED 05.08.19

REV	DATE	DESCRIPTION
C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

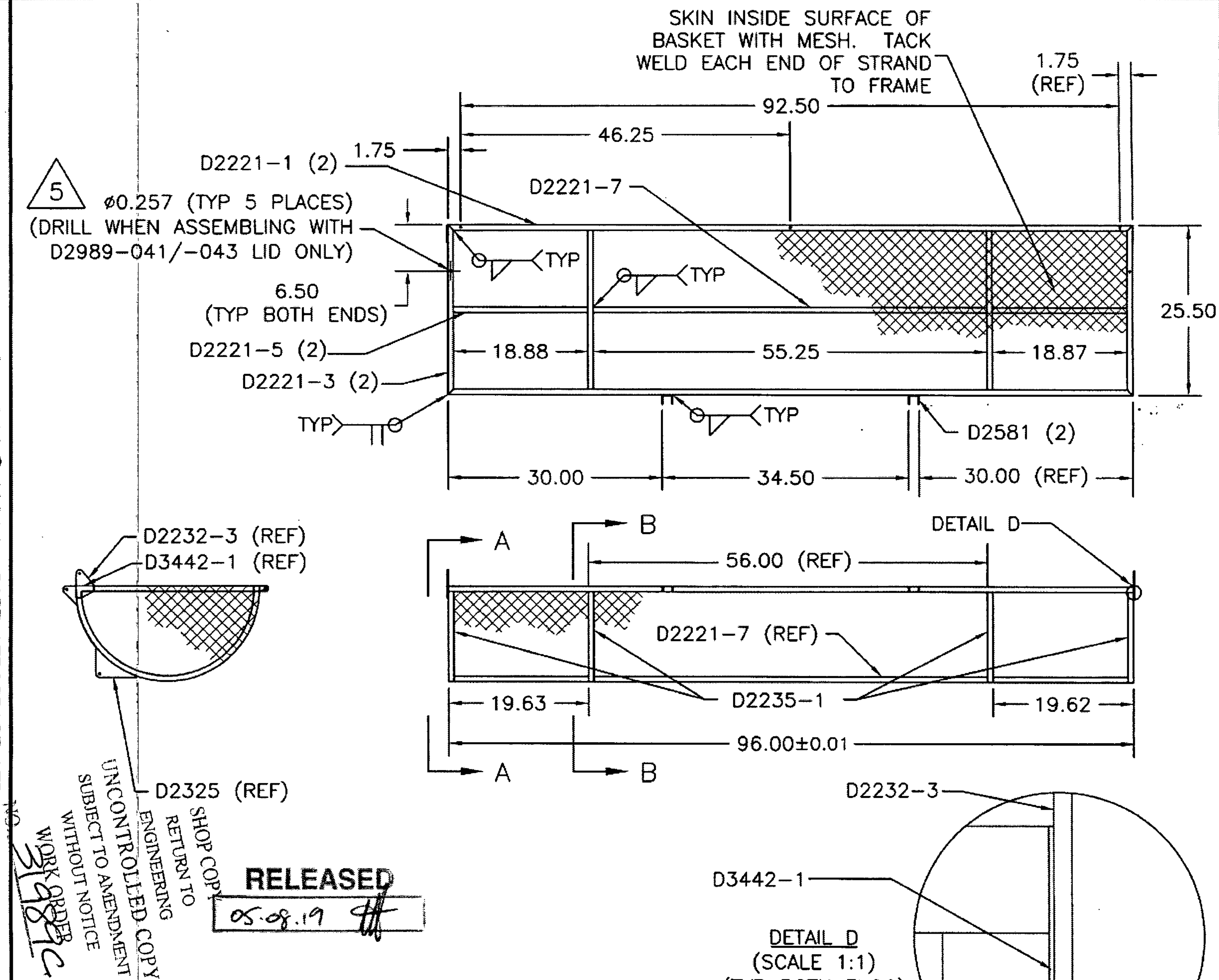
PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	———	96.00	RIB
D2221-3	2	———	25.50	RIB
D2221-5	2	18.88	———	RIB
D2221-7	1	55.25	———	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 31989C

D2221-1/-3/-5/-7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID



D2221 BASKET BASE ASSEMBLY

1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
2) WELD PER DART QSI 004
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

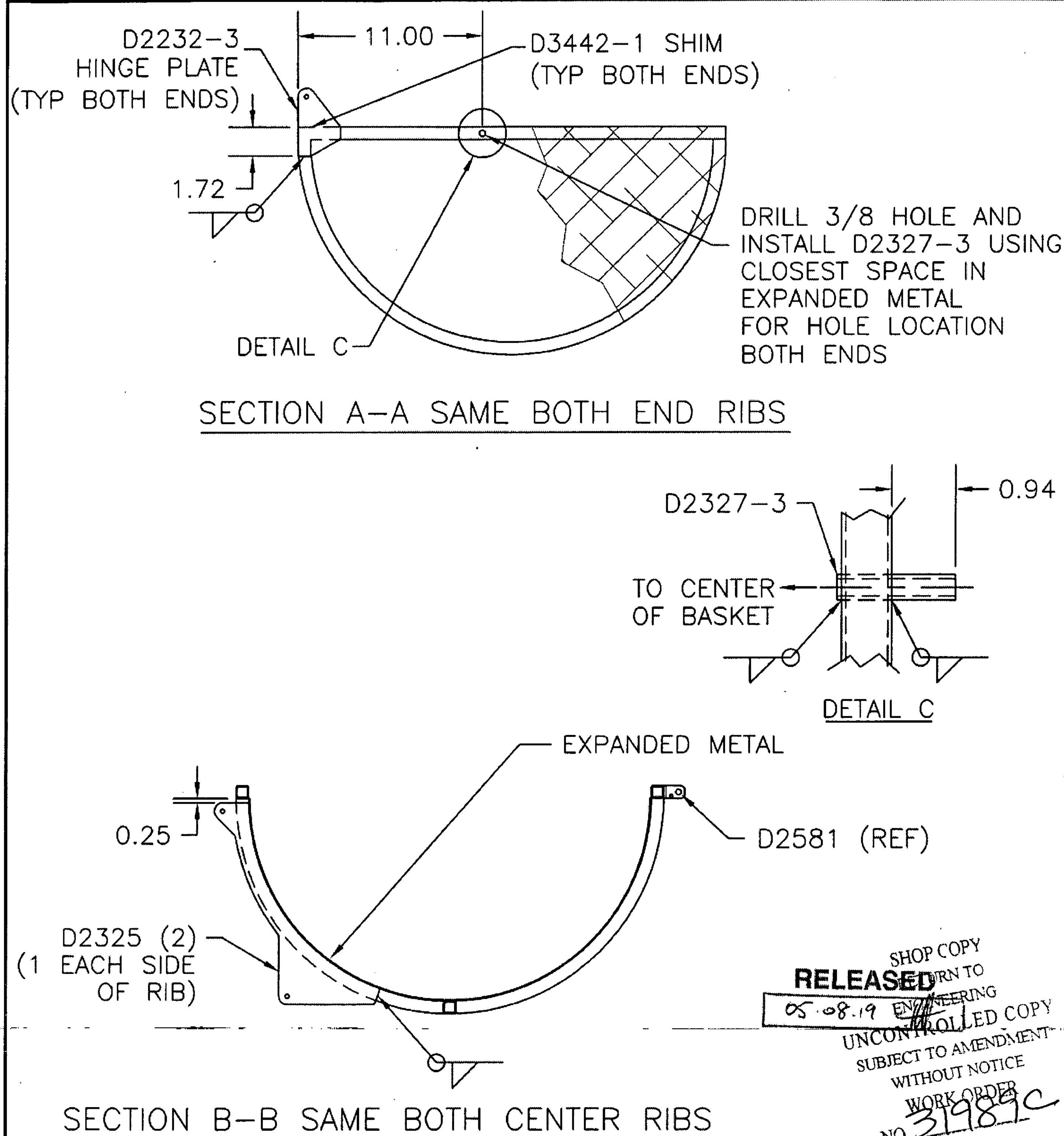
DART

DESIGN	BW
DRAWN BY	PH
CHECKED	
APPROVED	
DATE	05.06.07
DRAWING NO.	D2221
TITLE	BASKET BASE ASSEMBLY (350)
SCALE	1:20
SHEET	2 OF 3
REV.	F

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DART

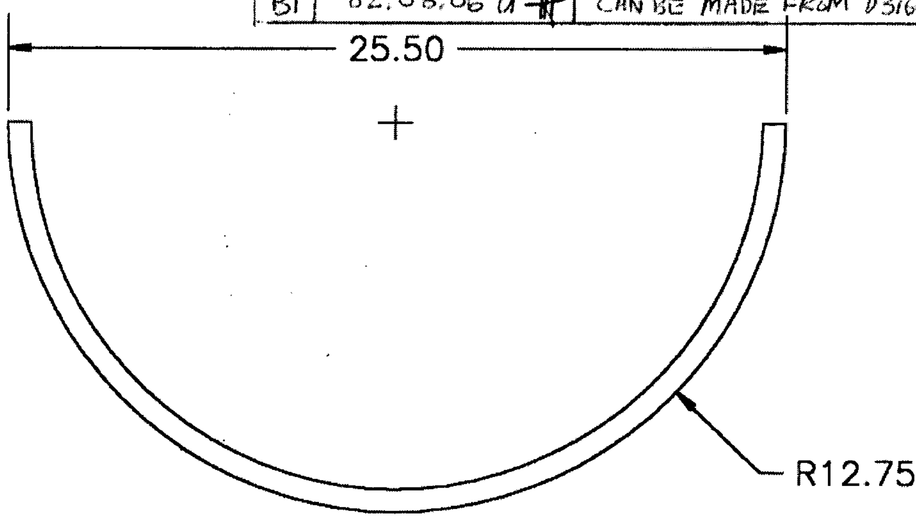
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
BW	PH	
CHECKED	APPROVED	DRAWING NO. D2221 — REV. F — SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350) — SCALE 1:8



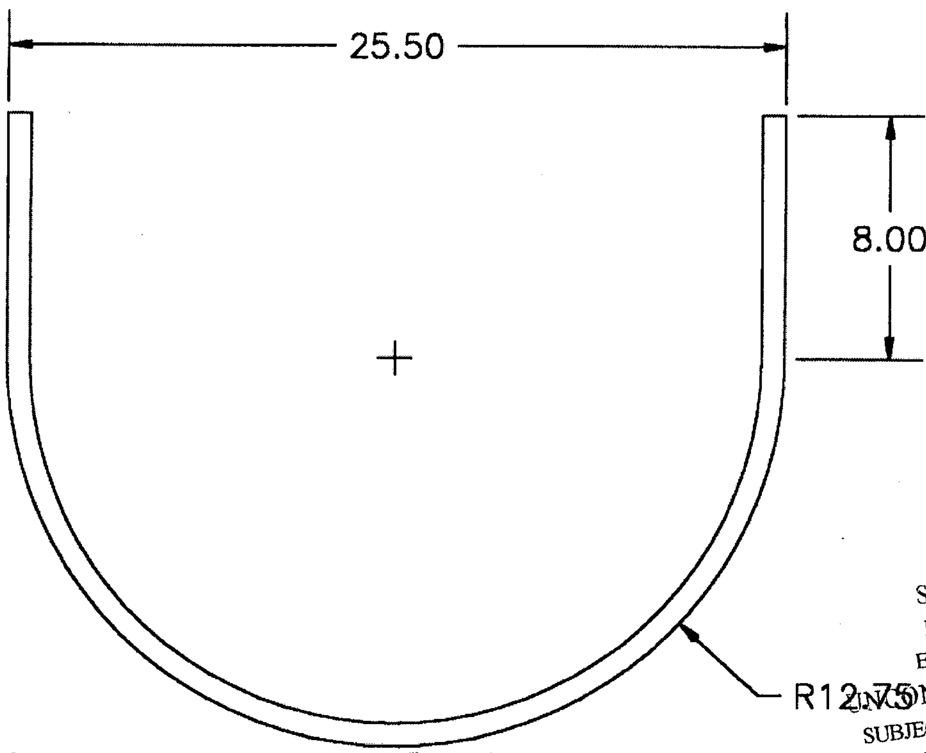
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED	APPROVED	DRAWING NO. D2235 — REV. B — SHEET 1 OF 1
[signature]	BW	
DATE		TITLE: BASKET RIBS — SCALE
94:12:16		
B1	02.08.06	CAN BE MADE FROM D3166-1

RELEASED 960507



D2235-1



D2235-3

SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 31989C

CAN BE MADE FROM D3166-1 B1

MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

Dart Aerospace Ltd.

Date: Monday, 4/23/2007 1:51:57 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BASKET LID ASSEMBLY
Job Number	: 31989A		
Estimate Number	: 10206		
P.O. Number	: N/A	**Part Number**	: D2989041
This Issue	: 4/23/2007 **S.O. No.** : N/A	**Drawing Number**	: D2989 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: B
Previous Run	: 31988A	**Material**	: N/A
Written By	:	**Due Date**	: 4/30/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.04.23		
Comment	: Est Rev:I Removed D2989-043 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31663	Basket Hoop

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
✓ Pick:
Qty.(1) D3166-3 Batch: B 30144 07/06/19

2.0	D2581	Mounting Bracket

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
✓ Pick:
Qty Part number Description Batch
2 D2581 Mounting Brackets B31189 07.06.26

3.0	D23273	Spacer Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
✓ Pick:
Qty Part number Description Batch
2 D2327-3 Bushing B31785 07.06.26

4.0	D2506	Placard

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
✓ Pick:
Qty Part number Description Batch
1 D2506 Label Plate B30548 07.06.26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:51:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET LID ASSEMBLY

Job Number: 31989A
Part Number: D2989041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)
Pick:
Qty Part number Description Batch
15sf M304EX0.75-16F Expanded Metal m104001

✓ 07.06.25

Seq. #:	Machine Or Operation:	Description :
6.0	M304TS0750W065	304 SQ Tube.75x.75x.065W

Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: M103946

✓ 07/06/18

Seq. #:	Machine Or Operation:	Description :
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989 07/06/19

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material 07/06/19

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989Identify as D2989-041 07.06.25

Seq. #:	Machine Or Operation:	Description :
8.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/06/29

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/06/26

Seq. #:	Machine Or Operation:	Description :
10.0	POWDER COATING	POWDER COATING

m 104144

Comment: POWDER COATING

BR/M 07-06-27

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: __________ **PAR #:** _____ **Fault Category:** __________ **NCR:** Yes (No) **DQA:** D **Date:** 01/06/09

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 1:51:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BASKET LID ASSEMBLY

Job Number: 31989A **Part Number:** D2989041

Job Number:

Seq. #:	Machine Or Operation:	Description :
	2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4 Spray Paint Black: M104533 Wing Walk: M104755	ML 07/06/28
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: Inspect Powder Coat and Wing Walk	ML 07/06/28
12.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/06/29

Job Completion

07.06.29

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN. DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2989 REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY SCALE NTS

A	00.10.27	NEW ISSUE
B	05.06.07	ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS

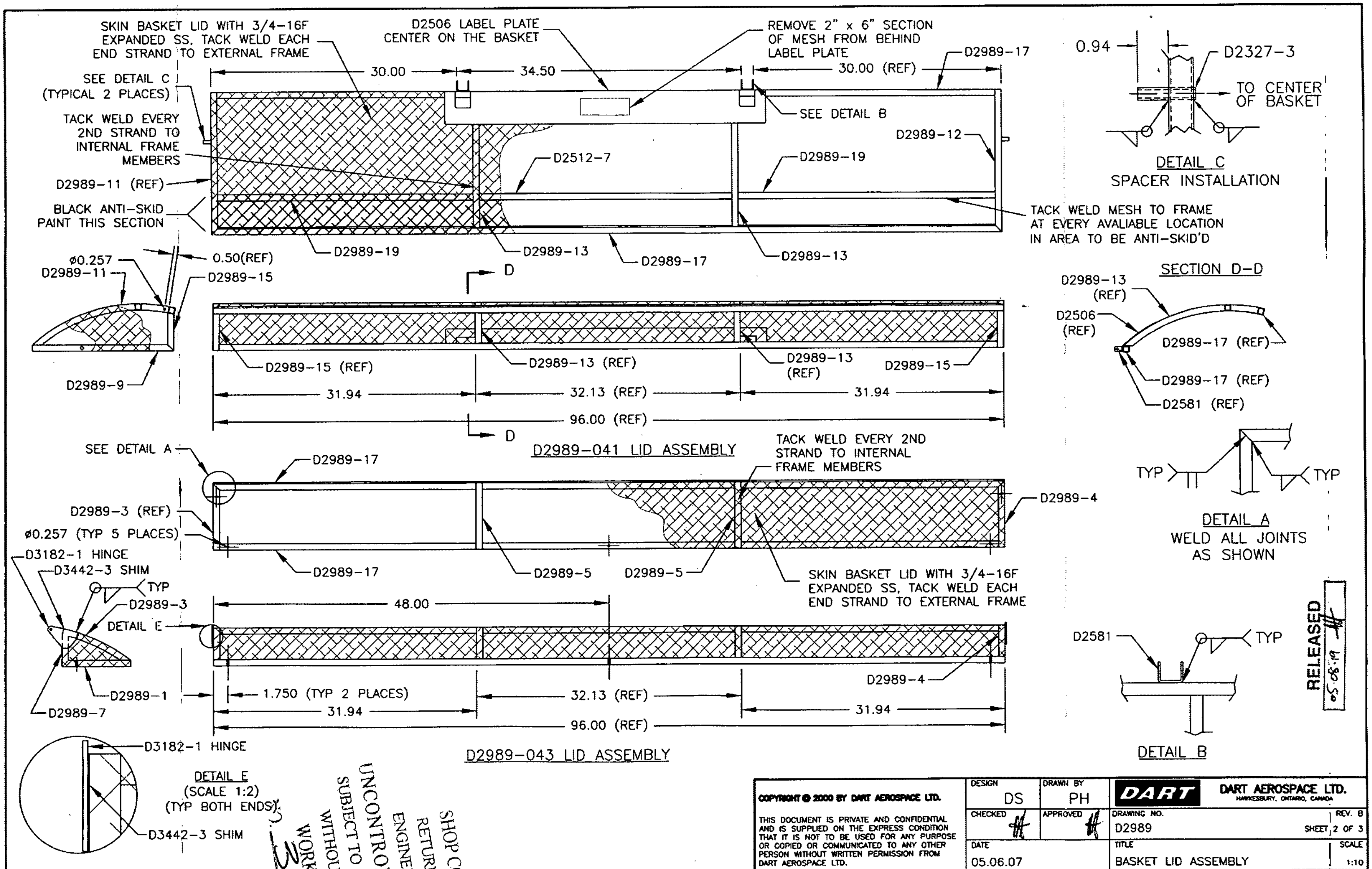
RELEASED 05.08.19

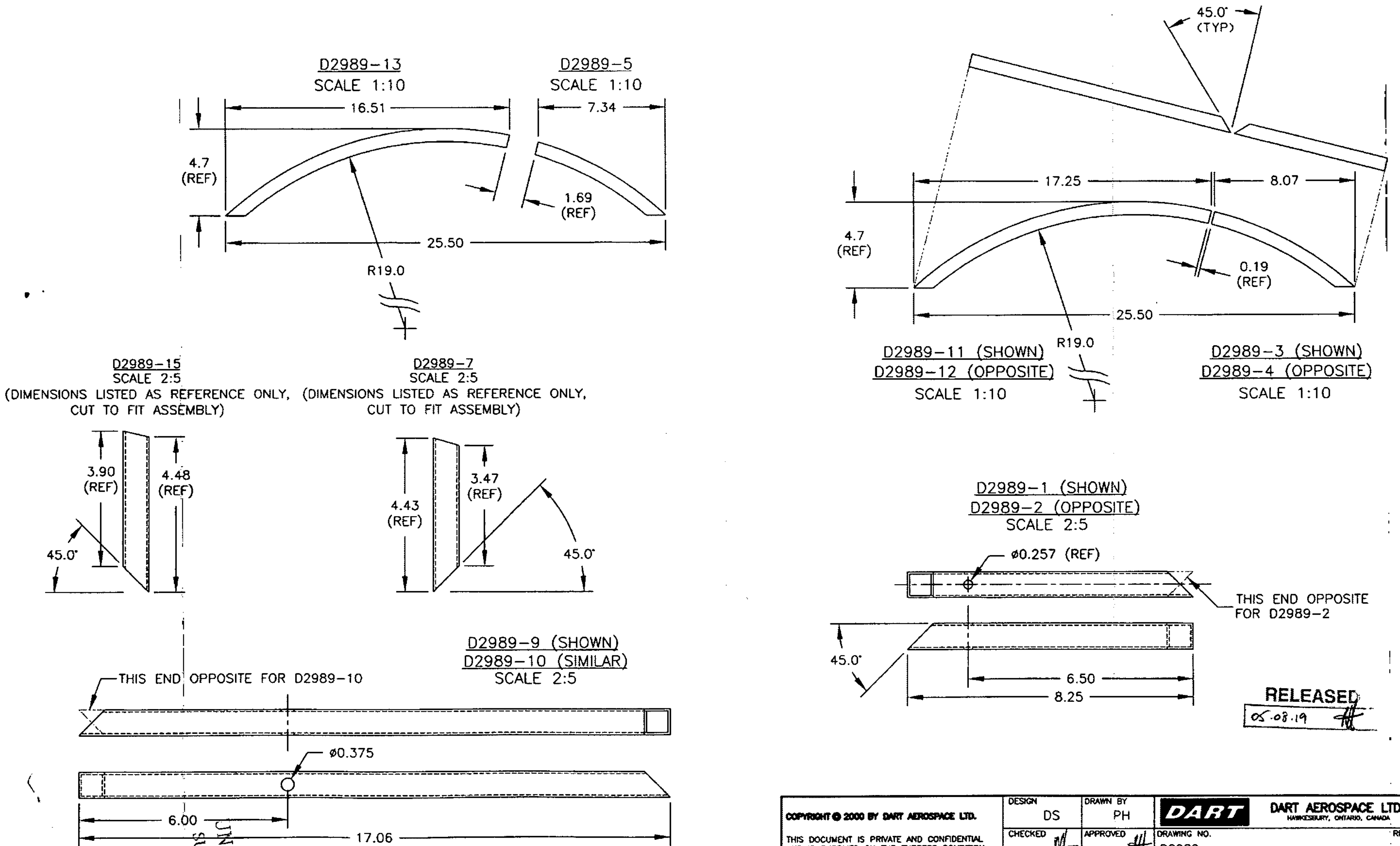
PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		**D2989-041**	**BASKET LID ASSEMBLY (OUTSIDE)**
	X	**D2989-043**	**BASKET LID ASSEMBLY (INSIDE)**
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
D2506 LABEL PLATE CENTER ON THE BASKET
REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE
D2989-17
30.00
34.50
30.00 (REF)
0.94
D2327-3
TO CENTER OF BASKET
SEE DETAIL C (TYPICAL 2 PLACES)
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
SEE DETAIL B
D2989-12
D2512-7
D2989-19
D2989-11 (REF)
BLACK ANTI-SKID PAINT THIS SECTION
DETAIL C
SPACER INSTALLATION
TACK WELD MESH TO FRAME AT EVERY AVALIABLE LOCATION IN AREA TO BE ANTI-SKID'D
D2989-19
D2989-13
D2989-17
D2989-13
ø0.257
D2989-11
0.50(REF)
D2989-15
D
SECTION D-D
D2989-13 (REF)
D2506 (REF)
D2989-17 (REF)
D2989-17 (REF)
D2581 (REF)
D2989-9
D2989-15 (REF)
D2989-13 (REF)
D2989-13 (REF)
D2989-15
31.94
32.13 (REF)
31.94
96.00 (REF)
D
D2989-041 LID ASSEMBLY
SEE DETAIL A
D2989-17
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS
TYP
TYP
D2989-3 (REF)
ø0.257 (TYP 5 PLACES)
D2989-4
DETAIL A
WELD ALL JOINTS AS SHOWN
D3182-1 HINGE
D3442-3 SHIM
TYP
D2989-3
DETAIL E
D2989-17
D2989-5
D2989-5
SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME
48.00
D2581
TYP
RELEASED
05.08.19
D2989-4
D2989-1
1.750 (TYP 2 PLACES)
32.13 (REF)
31.94
D2989-7
31.94
96.00 (REF)
DETAIL B
D3182-1 HINGE
DETAIL E
(SCALE 1:2)
(TYP BOTH ENDS)
D3442-3 SHIM
D2989-043 LID ASSEMBLY
COPYRIGHT © 2000 BY DART AEROSPACE LTD.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.
DESIGN DS
DRAWN BY PH
CHECKED
APPROVED
DATE 05.06.07
DART
DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D2989
REV. B
SHEET 2 OF 3
TITLE BASKET LID ASSEMBLY
SCALE 1:10



DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2989 — REV. B — SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY — SCALE 1:10

Dart Aerospace Ltd.

Date: Monday, 4/23/2007 1:52:07 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BASKET LID ASSEMBLY
Job Number	: 31989B		
Estimate Number	: 10207		
P.O. Number	: N/A	**Part Number**	: D2989043
This Issue	: 4/23/2007 **S.O. No.** : N/A	**Drawing Number**	: D2989 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : LARGE FAB ASSY	**Drawing Revision**	: B
Previous Run	: 31988B	**Material**	: N/A
Written By	:	**Due Date**	: 4/30/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.04.23		
Comment	: Est Rev:1 Removed D2989-041 05-11-03 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D31821	Hinge

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D3182-1 Hinge B31986 ✓ 07.06.25

Seq. #:	Machine Or Operation:	Description :
2.0	D34423	Shim

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part number Description Batch
2 D3442-3 Shim B26740 ✓ 07.06.25

Seq. #:	Machine Or Operation:	Description :
3.0	M304EX07516F	Expanded Metal Flat Stai

Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)
Pick:
Qty Part number Description Batch
8sf M304EX0.75-16F Expanded Metal M10400l ✓ 07.06.25

Seq. #:	Machine Or Operation:	Description :
4.0	M304TS0750W065	304 SQ Tube:75x.75x.065W

✓ **Comment:** Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)
3/4" x 3/4" x 0.063" wall 304/316 SStubing.
Batch: M10 3946 07/06/19

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** D **Date:** 07/06/27

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 4/23/2007 1:52:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: BASKET LID ASSEMBLY

Job Number: 31989B
Part Number: D2989043

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989 SJ. 07/06/19
Note:D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material SJ. 07/06/19

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid 07-06-25

6.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION 07/06/26

7.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK 07/06/26

8.0	POWDER COATING	POWDER COATING

m 104 144

Comment: POWDER COATING

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989 BK./M. 07-06-27.

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: Inspect Powder Coat 07/06/28

10.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/06/29

Job Completion

a 07-06-29

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2989 REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY SCALE NTS

A	00.10.27	NEW ISSUE
B	05.06.07	ADD SHIM UNDER HINGES,UPDATE LID DIMENSIONS

RELEASED
05.08.19

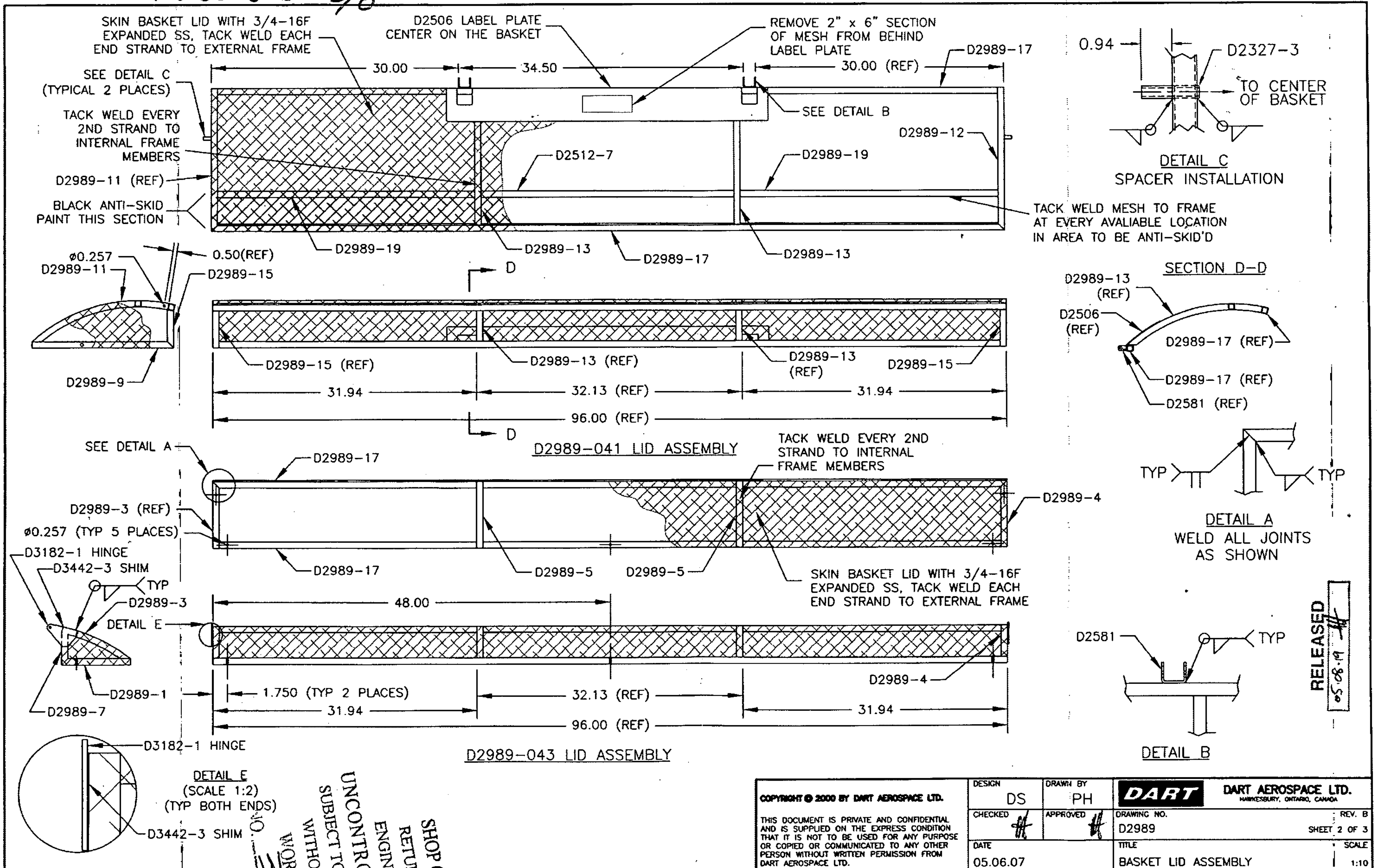
PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

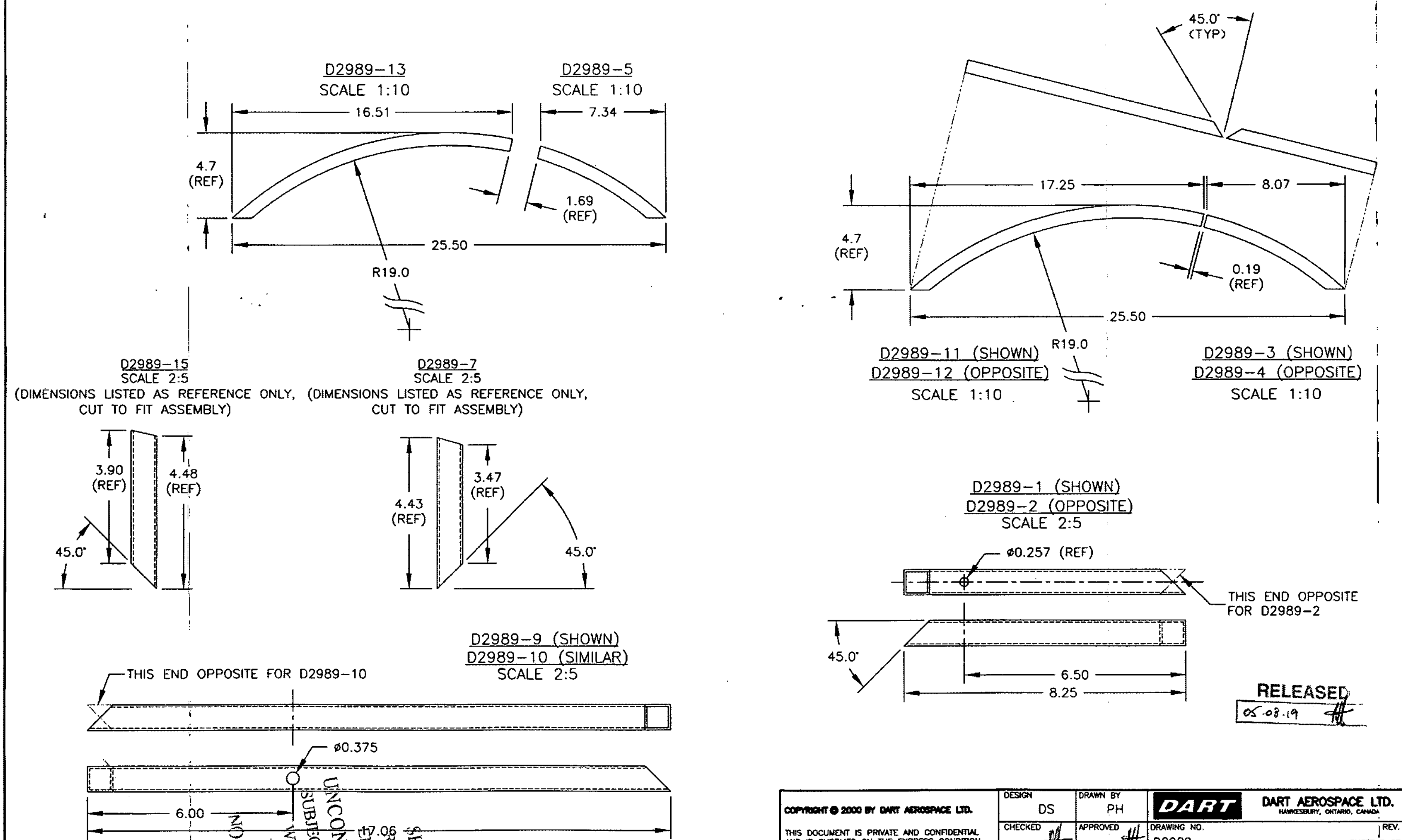
NOTES:

1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
3) WELD PER DART QSI 004
4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
5) ALL DIMENSIONS ARE IN INCHES
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

2X 96"
2X 25.500"
2X 31.188" 3/16
1X 30.625" 5/8



DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2989 — REV. B — SHEET 2 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY — SCALE 1:10



RELEASED 05.08.19

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2989 — REV. B — SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY — SCALE 1:10